

WHAT IS CLAIMED IS:

1. A laminated beverage carrier comprising a laminated composite sheet folded and secured in the configuration of a box, said sheet composed of a non-corrugated base layer of unbleached cellulosic fibers and having an inner surface and an outer surface, an outer layer of separately formed non-corrugated paper having an inner surface and an outer surface, printed graphics disposed on the outer surface of the outer layer, and adhesive disposed between the inner surface of the outer layer and the outer surface of the based layer and serving to bond the outer layer to said base layer, the inner surface of said outer layer being bonded continuously to the outer surface layer of said base layer.

2. The laminated beverage carrier of claim 1 wherein said cellulosic fibers are selected from the group consisting of unbleached virgin kraft pulp and recycled pulp.

3. The laminated beverage carrier of claim 1 further comprising a layer of water absorbent material disposed on the inner surface of said base layer.

4. The laminated beverage carrier of claim 3 further comprising a film of water resistant adhesive bonding said absorbent material to said base layer.

5. In a method of producing a laminated package, the steps comprising producing a base layer of cellulosic fibers, producing a sheet of paper having a smooth printable

first surface, printing graphics on the smooth printable first surface of said paper sheet, continually moving the base layer in a path of travel, continuously applying the printed sheet to a first surface of said moving base layer, while applying adhesive between contiguous surfaces of said base layer and said printed paper sheet to bond the printed paper to said moving base layer and produce a laminated structure with said printed paper sheet being bonded to substantially the entire surface area of the base layer.

6. The method of claim 5 wherein said laminated package is a beverage carrier.